


Date: Thursday, 8/24/2006 10:36:52 AM
 User: Eric Charbonneau

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: INITIAL PROTOTYPE TEMPLATE
Job Number	: 00053A	Part Number	: INITIAL PROTOTYPE D3524-1
Estimate Number	: 10068	Drawing Number	: D3524
P.O. Number	: N/A	Project Number	: P604-654
This Issue	: 8/24/2006 S.O. No. : N/A	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Due Date	: 5/15/2006
Previous Run	: 00052A	Qty:	2 Um: Each
Written By	: 		
Checked & Approved By	:		
Comment	: Project #:		
	: Description:		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering
 Comments:

- M 6061 T6 B0250 X0400 1/4" x 600" alum. bar 1 batch M100351 (0.210)
- Cut as per Dwg D3524 SAD 06.09.25 (2)
- Mill as per Dwg D3524 E 06.05.28
- QC2 E 06.08.29
- QC8 JMM 06.08.30
- Acid etch & Alodine → DL 06.09.01 (1)
- Powder coat black sandtex (4.3.5.7) 5
- QC3 E 06.09.01

2.0	PG	PURCHASING
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PURCHASING

Attached certificate of conformity for raw material and subcomponents use for this w/o 06/09/25 (1)

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Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00053A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

3.0 PACKAGING 1 PACKAGING RESOURCE #1



not
required

CB

Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PACKAGING RESOURCE #1
Identify "FOR ENGINEERING USE ONLY" and distribute to engineering.

4.0 ENGINEERING 1 ENGINEERING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
ENGINEERING RESOURCE #1
Approval of project manager _____

PART WENT TO HAI. PART NOT
APPROVED AND NOT AIRWORTHY
CB 07.07.13

5.0 DC DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
DOCUMENT CONTROL
Inspection Level 21

DDK/124

Job Completion

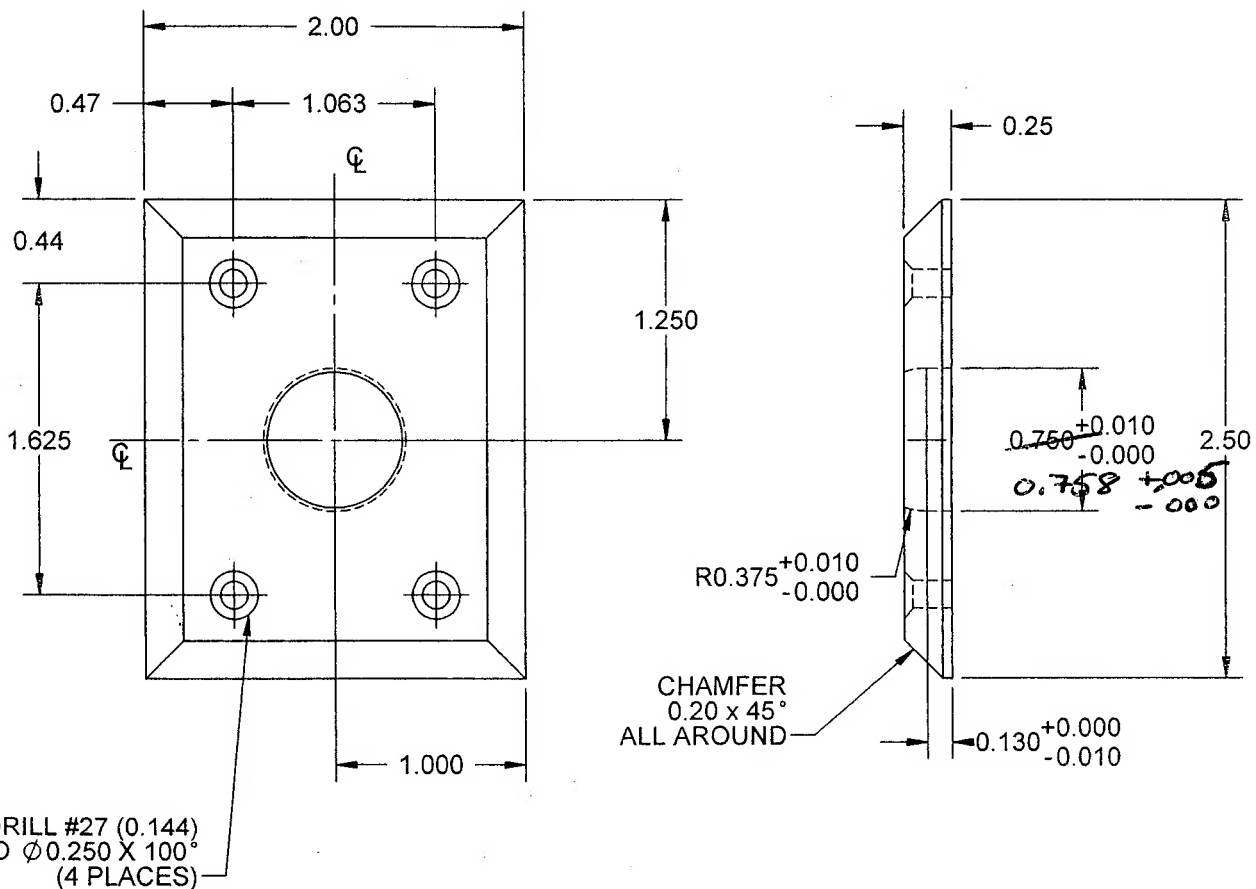


PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3524	REV. A SHEET 1 OF 2
DATE 06.05.02	TITLE UPPER AND LOWER PLATE		SCALE 1:1
A	06.05.02	NEW ISSUE	

UNDER REVIEW

06.08.15 CB
prototype



D3524-1 LOWER PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR (QQ-A-250/8 OR QQ-A-200/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART SYMMETRICAL ABOUT ϕ

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KAISER ALUMINUM
111 S 74 E Ave
Tulsa, OK 74145

COPPER & BRASS SALES
CUSTOMER PICK-UP
5755 GRANT AVE
CLEVELAND, OH 44105

PAGE 1

COPPER & BRASS SALES

SOUTHFIELD MI 48086 CI7994

01/29/06

SOLD TO

PURCHASE ORDER

DATE PRINTED

SOLD TO

PURCHASE ORDER

DATE PRINTED

019842-4

.250 X 6.000 RECT BAR

CUSTOMER PART NUMBER DESCRIPTION

803502-001

385 111

6061-T6511

RELEASE-ITEM

LOT

ALLOY/TEMPER

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS(KSI)	YTS(KSI)	%Elong in 2"	HARDNESS	CONDUCT.	BEND
385	111 . 0001 0001	48.7	45.6	12.7		N/A	N/A
385	111 0001 0002	48.9	45.9	12.6		N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

6061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Others
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05 0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00 0.00

APPLICABLE REQUIREMENTS:

ASTM-B221-02-STENCILED
ASME-SB221 1998 SECT II
AMS-QQ-A-200/8
UNS#96061

Kaiser Aluminum & Chemical Corp. ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgment form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

M100351